

CLASSIFICATION ~~CONFIDENTIAL~~ **CONFIDENTIAL**
 CENTRAL INTELLIGENCE AGENCY REPORT
 INFORMATION FROM
 FOREIGN DOCUMENTS OR RADIO BROADCASTS CD NO.

50X1-HUM

COUNTRY USSR DATE OF INFORMATION 1948
 SUBJECT Economic; Technological - Machine tools
 HOW PUBLISHED Monthly periodical DATE DIST. 18 May 1950
 WHERE PUBLISHED Moscow NO. OF PAGES 2
 DATE PUBLISHED Mar 1948
 LANGUAGE Russian SUPPLEMENT TO REPORT NO.

THIS DOCUMENT CONTAINS INFORMATION AFFECTING THE NATIONAL DEFENSE OF THE UNITED STATES WITHIN THE MEANING OF ESPIONAGE ACT 50 U. S. C. 31 AND 32, AS AMENDED. ITS TRANSMISSION OR THE REVELATION OF ITS CONTENTS IN ANY MANNER TO AN UNAUTHORIZED PERSON IS PROHIBITED BY LAW. REPRODUCTION OF THIS FORM IS PROHIBITED.

THIS IS UNEVALUATED INFORMATION

SOURCE Vestnik mashinostroyeniya, No 3, 1948, (FDB Per Abs 62T36).

NEW STANDARDS FOR MACHINE TOOLS

The All-Union Committee for Standards under the Soviet of Ministers USSR has confirmed new GOST for metalworking, machine-tool parts and units, measuring and metal-cutting tools, attachments, tolerances, and fits.

The new standard for turret heads with vertical axis, GOST 3859-47, extends to heads for machine tools included in GOST 3179-46, and specifies two types of heads: Type A, round, and Type B, hexahedral. The maximum diameters for bars, being machined on Type A heads are 12, 18, and 25 millimeters and for Type B, 25, 35, 50, 65, 85, and 110 millimeters. This standard has considerably increased the dimensions of heads.

The standard for right-angle plates, electromagnetic plates, and plates with permanent magnets, GOST 3860-47, regulates the basic dimensions of these plates which, in metalworking, are used for fastening work pieces. The standard has specified the width of the plates as 150 and 200 millimeters, and the length with the first width at 300, 400, and 550 millimeters and with the latter width at 400, 550, and 750 millimeters. The width of the plates corresponds to the width of the tables of surface grinders for which purpose they are most frequently used. The remaining dimensions depend on design considerations.

The standard for round rotary tables, GOST 3861-47, gives the basic specifications of tables which are used in metalworking and in particular for work on vertical milling machines. The basic specification on which the dimensions of the table are established is the diameter of the rotating part of the table, since the effective area of an attachment depends on it. The standard has established the following diameters: 250, 350, 500, and 700 millimeters, the increase factor being 1.4. These dimensions correspond most closely to the dimensions of the working surface of the milling machine tables. The 700-millimeter size is provided for heavy machine-tool building. The remaining sizes of tables, established by the standard, have been selected in accordance with design considerations. The 250-millimeter rotary tables have been specified for hand feed only, and the remaining, with hand and mechanical feed.

CONFIDENTIAL

- 1 -

CLASSIFICATION		CONFIDENTIAL		DISTRIBUTION									
STATE	<input checked="" type="checkbox"/>	NAVY	<input checked="" type="checkbox"/>	NSRB									
ARMY	<input checked="" type="checkbox"/>	AIR	<input checked="" type="checkbox"/>	FBI									

CONFIDENTIAL

50X1-HUM

The standard for three-jaw self-centering lathe chucks, GOST 2675-47, specifies two types of chucks, A and B. Type A chuck does not have an intermediate mounting plate.

The standard for independent four-jaw lathe chuck, GOST 3890-47, includes two types of chucks: Type A for threaded spindles and Type B for flanged spindle noses.

The standard for intermediate mounting plates for lathe chucks, GOST 3889-47, extends to adapters for lathe chucks Type A, GOST 2675-47, for threaded spindle noses specified in OST 428.

A new standard has been set for general-purpose lathe chucks, GOST 1654-47, which contains technical specifications and regulates the inspection of self-centering high-speed chucks for static equilibrium, accuracy, and durability, as well as for marking and packing.

The new standard for thread plug (rolikovyye) gauges is for checking external metric threads with a pitch from 0.5 to 3 millimeters and a diameter from 6 to 52 millimeters.

The new standard for pitch gauges, GOST 3883-47, is for measuring the basic pitch of external-meshing cylindrical gears having a module from 2 to 20 millimeters.

The standard for electrocontact transmitting elements of instruments for checking linear dimensions, GOST 3899-47, has been approved. These are used in single or multimeasuring attachments with light or other type signals, in automatics for checking and sorting parts, in attachments for checking parts which are being machined, etc.

The standard for shell-type face millers having diameters from 250 to 600 millimeters with inserted high-speed steel blades, GOST 3876-47, encompasses only the basic dimensions of the mills and pertains to the method of attaching them to the spindle of the milling machine. This standard replaces GOST 1092-41, as far as dimensions over 225 millimeters are concerned.

The new standard for hard-alloy-tipped face millers for high-speed milling of steel, GOST 3879-47, includes millers with tapered shanks, shell-type mills, geometric specifications for previously ground blades, geometric specifications for sectional blades, and the method of securing the blades.

The standard for tolerances and fits in dimensions, less than one millimeter, GOST 3047-47, replaces GOST 3047-45.

- E N D -

CONFIDENTIAL

- 2 -

CONFIDENTIAL